



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3199-1
Job Sheet 168700



Part No: D3199-1

Job Qty: 120 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/21/17

Job Tracking No:

Due Date: 11/28/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Bell Helicopters (CBELL04)

Canadian Supply Centre, Bay 101, 58 Aero Drive NE Calgary, AB, T2E 8Z9 Canada ph:(403) 275-3555

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea	11/27/17	11/27/17	0.00	0.00	Start Up Waterjet		SR
100	Waterjet	120 pcs	11/27/17	11/27/17	0.00	3.55	Waterjet1		SC DAS
120	QC	120 pcs	11/27/17	11/27/17	0.00	0.00	QC8		38
130	Small Fab	120 pcs	11/27/17	11/27/17	0.01	5.28	Small Fab		9-BB DAS
140	QC	120 pcs	11/27/17	11/27/17	0.00	0.00	QC5		38
150	Powdercoat	120 pcs	11/28/17	11/28/17	0.00	1.35	Powdercoat3		BR 17-11-29
160	QC	120 pcs	11/28/17	11/28/17	0.00	0.00	QC3		38
170	Packaging	120 pcs	11/28/17	11/28/17	0.00	0.00	Packaging3	5000 SL	21
180	QC21-SA	120 Ea	11/28/17	11/28/17	0.00	0.00	QC21		21

Part Op 100 - Cut as per Dwg D3199 Deburr if required

Descriptions: 130 - Form as per dwg D3199 use DT9723

150 - START TIME: 11:30 FINISH TIME: 5:20 O.V.T: 300° M136370.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	12	116	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.210inches + 0.005 - 0.001	0.215 0.209		
2	Bracket	0.575inches ± 0.010	0.585 0.565		
3	Bracket	1.090inches ± 0.010	1.100 1.080		
4	Bracket	2.015inches ± 0.010	2.025 2.005		
5	Bracket	2.971inches ± 0.010	2.981 2.961		
6	Bracket	1.830inches ± 0.010	1.840 1.820		
7	Bracket	4.830inches ± 0.010	4.840		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐									
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Composite ☐	Supplier ☐																						
Date : _____ S013398 Bracket		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																					
PART NO: D3199-1 Revision: Operation: Start up Operation Change No:		Mfg Date: 11/24/17 Job No: 168700																					
Environme Desig Doc/Dat Equip/Toolin Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes																				
OTHER : _____		GORY <table style="width:100%;"> <tr> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabelled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabelled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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8	Bracket	4.030inches ± 0.010	4.820
			4.040
			4.020

Plex 11/21/17 10:40 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
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